

Abstract of the Disclosure

Batching of currently supplied articles with non-uniform weights into portions of a uniform target weight is effected by passing the articles through a weighing station (6, 8) to a distribution system (12), in which the articles (4) are selectively allocated to a plurality of receiver bins (14). Probability calculations based on a regularly updated record of the weight distribution of a relatively high number of newly weighed articles and the probability of each new incoming article complete a portion of target weight are used to determine which of a plurality of bins the article should be diverted into from a stream of incoming articles. The process can be used for production of mixed jobs on multiple lines, e.g., portions with one type of parts being formed from the stream articles in one line of batching bins and portions of a different type of parts, or portions with differing numbers of parts, or of different weights being formed from the stream articles in a parallel line of batching bins.